

Work Order ID 61973

Monday, September 13, 2010 11:30:04 AM



Page 1

Item ID: D4084-1

Accept



Setup Start



Revision ID:

Item Name: Maintenance Step

Stop



Start Date: 9/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 10/03

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr								
D4084	A								

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FA960

FOLIO REV: A

DWG REV: A

2-Deburr any rough edges

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

0.00

B.A 10/10/21

10

Ø

130



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

B.A 10/10/26

10

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61973

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Chemical Conversion Coat per QSI005 4.1

0.00

PL 10-10-26

HandFinish

Memo

0.00

10.

Hand Finishing

150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

N/A Part

*10.10.25.**As per CAR.**E 10.24*

160



QC3- Inspect Part Finish

0.00

Memo

0.00

QC

Quality Control

=> M 10/10/25

10 J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61973

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Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: 19

0.00

10/10/27 102 J

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/28 J
MF
10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:30:08 AM

Page 1

Work Order ID: 61973



Parent Item: D4084-1



Parent Item Name: Maintenance Step

Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-09-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No				Each	43.0000	1	10			

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT042	43	
59196	3	
61250	40	

H-A 10/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61973
Description: MAINTENANCE STEP	Part Number:	D4084-1
Inspection Dwg: D4084 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.891	+ .010 / -.001	0.894	✓		Vern	GA-01
0.080	+/- .010	0.072	✓		H-G	31006
Ø 0.991 X 45°	+/- .010	Ø 0.996 X 45°	✓		Vern	GA-01
1.40	+/- .030	1.399	✓		H-G	31006
0.89	+/- .030	0.899	✓		Vern	GA-01
0.66	+/- .030	0.658	✓		"	"
1.73	+/- .030	1.736	✓		Vern	GA-01
3.63	+/- .030	3.630	✓		"	"
2.25	+/- .030	2.2419	✓		"	"
1.13	+/- .030	1.129	✓		H-G	31006
0.25	+/- .030	0.248	✓		Mic	118-120
2.60	+/- .030	2.600	✓		Vern	GA-01
0.50	+/- .030	0.500	✓		Mic	118-120
R 0.13	+/- .030	R 0.125	✓		R-G	Ref.
0.92	+/- .030	0.919	✓		Vern	GA-01
Ø 0.75	+ .008 / -.001	Ø 0.750	✓		"	"
0.97	+/- .030	0.967	✓		H-G	31006
2.650	+/- .010	2.648	✓		Vern	GA-01
4.00	+/- .030	4.000	✓		H-G	31006
Ø 0.339	+ .006 / -.001	Ø 0.342	✓		Vern	GA-01
Ø 0.850	+/- .010	0.850	✓		"	"
0.27	+/- .030	0.269	✓		Vern	GA-01
0.038	+/- .010	0.037	✓		H-G	31006

Measured by:	J. A	Audited by:		Preliminary Approval:	
Date:	10/10/25	Date:	10/10/26		Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

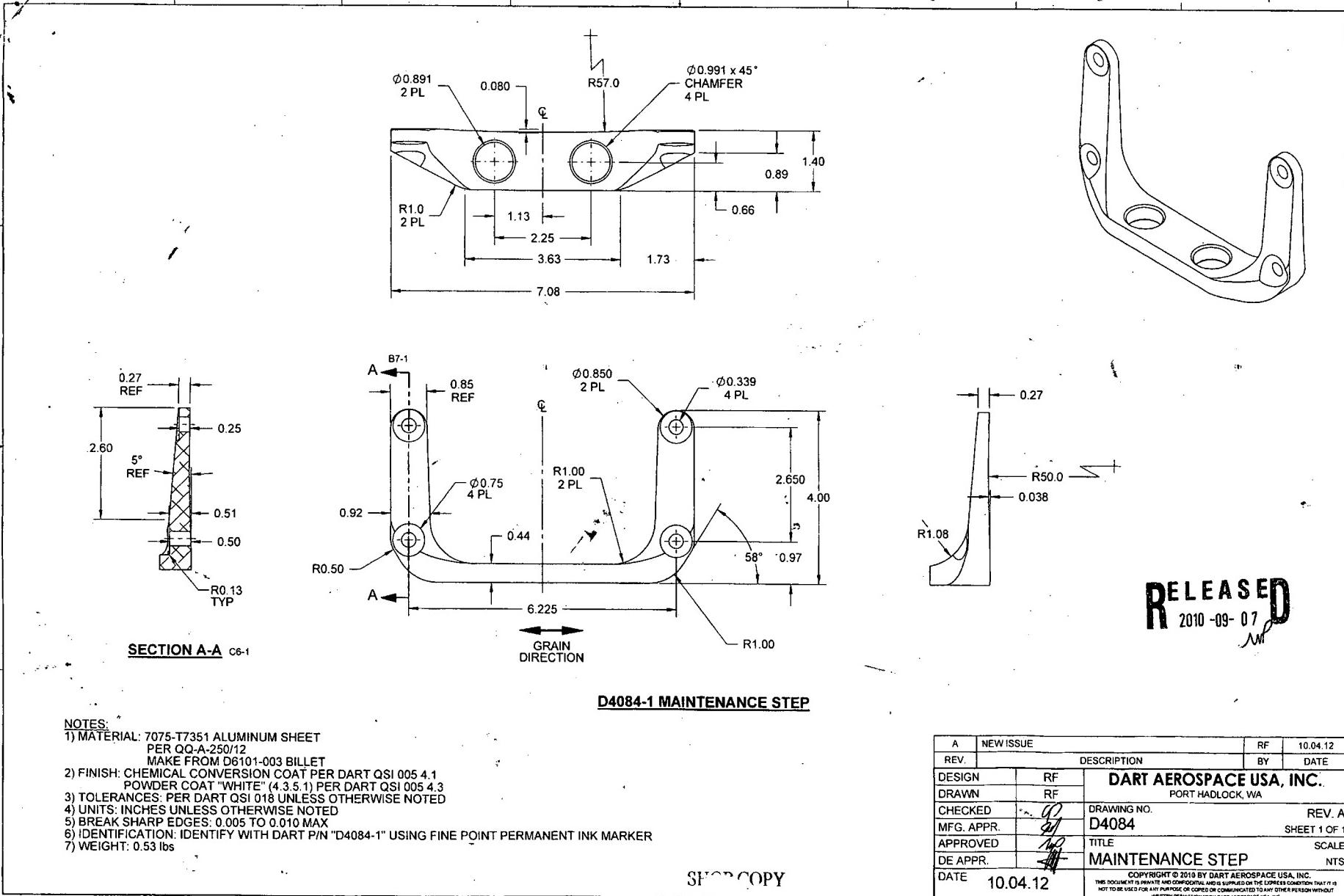
DART AEROSPACE LTD	Work Order:	61973
Description: MAINTENANCE STEP	Part Number:	D4084-1
Inspection Dwg: D4084 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>H.A.</u>	Audited by:	<u>✓</u>	Preliminary Approval:	
Date:	10/10/25	Date:	10/10/25	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



A	NEW ISSUE		RF	10.04.12
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	RF			
CHECKED	10	DRAWING NO.	D4084	REV. A
MFG. APPR.	21			SHEET 1 OF 1
APPROVED	10	TITLE	MAINTENANCE STEP	SCALE NTS
DE APPR.	10	DATE	10.04.12	

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10/10/913